

Date: Monday, 16/06/2008 10:25:18 AM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CROSSBOLT SPACER
Job Number : 39883
Estimate Number : 11010
P.O. Number : Part Number : D2649
This Issue : 16/06/2008 S.O. No. : Drawing Number : D2649 REV B1
Prsht Rev. : NC Project Number : N/A
First Issue : / / Type : MACHINED PARTS Drawing Revision : B1
Previous Run : 37859 Material :
Written By : Due Date : 30/06/2008 Qty: 500 Um: Each
Checked & Approved By : JUL 08.6.16
Comment : Est F 02.03.26 Added turning on Cobra NG

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T0375W058

6061-T6 Tube .375 x.058W



Comment: Qty.: 0.2975 f(s)/Unit Total: 148.7325 f(s)
6061-T6 Tube .375 x.058W

Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall

Batch M107244 = 491

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio A214 on cobra machine.

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BARThey

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

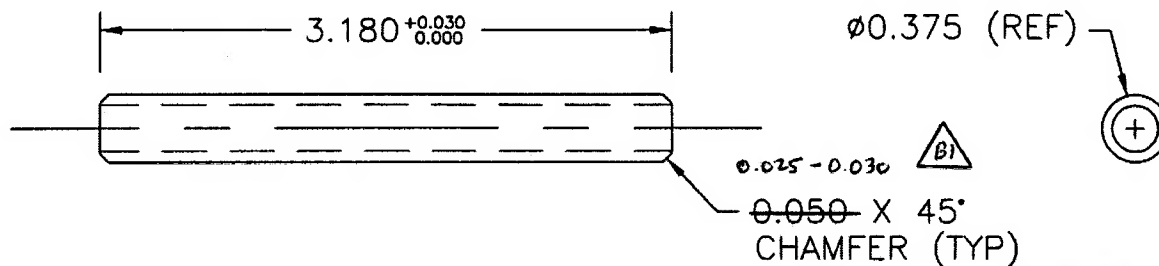
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DAJ</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DAJ</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
BI	CP 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31883

MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED